

Work Order ID 129937

Tuesday, April 07, 2015 7:07:13 AM

129937

Page 1

Item ID: D412-630-031 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pilot/Co-Pilot Folding Step LH - Low, High & Float Gear
 Start Date: 2/5/2015 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 2/23/2015 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-04-07 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-630	Rev N

100	Document Control	0.00							
100	DOCUMENT CONTROL		DAS						
DC	Memo	0.00	6						
Doc.Control -USB or Paperwork	Photocopy D412-630 bluefile & type labels per PPP412-630-031		9-89						

JUN 10 2015

110	Small Fab	0.00							
110	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per IIN D412-630								

ensure tension to retract step is 11 to 18 lbs before installing lockwire.

4X

15/04/20

120	QC5- Inspect part completeness to step on W/O	0.00							
120	QC								
Quality Control	Memo	0.00							
	****ensure tension to retract step is 11 to 18 lbs ****								
	ENSURE STEP IS A LH:								

(2)

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Page 2

Reference:

Stop ***NR2***

APR 21 2015

DAS
28
9-89

Quality Control

DAS	DAS
02	02
27	9-89
9-89	

JUN 10 2015

Packaging

Identify and pack for shipping as per PPP D412-630-031
ENSURE STEP IS A LH: _____
Location: 034 _____
PPP Rev: E

DAS
02
9-89

JUN 16 2015

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Item ID: D412-630-031

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pilot/Co-Pilot Folding Step LH - Low, High & Float Gear

Start Date: 2/5/2015 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 2/23/2015 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

ML5

JUN 17 2015

N150617

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Work Order ID: 129937

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Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Folding Step LH - Low, High & Float Gear

Start Date: 2/5/2015

Required Date: 2/23/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4		Purchased	No			130	Each	94.0000	1	4			

AN310-4

Nut

DAS 02 9-89
DAS 27 9-89

Location

Loc Qty

Loc Code

GA 25
M127815 25
ST331 69
M129913 68
M131320 1

**

DAS 6 9-89

DAS 28 9-89

AN310-5

Purchased

No

130

Each

68.0000

2

8

AN310-5

Nut

DAS 02 9-89
DAS 27 9-89

Location

Loc Qty

Loc Code

ST331 68
m129706 18
m131320 50

**

APR 11 2015

DAS 6 9-89

DAS 28 9-89

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Work Order ID: 129937

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Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Folding Step LH - Low, High & Float Gear

Start Date: 2/5/2015

Required Date: 2/23/2015

Start Qty: 4.00

Required Qty: 4.00

AN3C5A Purchased No 130 Each 1,183.000 3 12

AN3C5A

Bolt

~~121108~~

DAS	Location	Loc Qty	Loc Code	DAS
02	FG	5		6
9-89	122800	5		9-89
DAS	FP001	8		DAS
27	M131420	8		28
9-89	ST338a	826		9-89
	M130770	10		
	M130851	16		
	M131803	800		
	ST350	344		
	M131320	344		

AN44-C12

Purchased No

130 Each

15.0000

1

4

AN44-C12

Eye Bolt

DAS	Location	Loc Qty	Loc Code	DAS
02	FG	3		6
9-89	124829	3		9-89
DAS	ST339	12		DAS
27	M126293	12		28
9-89				9-89

AN4C15

Purchased No

130 Each

54.0000

1

4

AN4C15

Bolt

DAS	Location	Loc Qty	Loc Code	DAS
02	ST312A	49		6
9-89	M128936	49		9-89
DAS	ST343	5		DAS
27	M128634	5		28
9-89				9-89

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Work Order ID: 129937

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Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Folding Step LH - Low, High & Float Gear

Start Date: 2/5/2015

Required Date: 2/23/2015

Start Qty: 4.00

Required Qty: 4.00

AN5C11

Purchased

No

130

Each

10.0000

1

4

AN5C11

BOLT

DAS
02
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST338

10

M128773

10

**

DAS
6
9-89

DAS
28
9-89

AN5C15

Purchased

No

130

Each

15.0000

1

4

AN5C15

BOLT

DAS
02
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST337

15

M126012

1

M129934

14

**

DAS
6
9-89

DAS
28
9-89

D3454-1

Manufactured

No

130

Each

11.0000

1

4

D3454-1

Bushing

DAS
02
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST039

11

108642

11

**

DAS
6
9-89

DAS
28
9-89

D3454-3

Manufactured

No

130

Each

66.0000

2

8

D3454-3

Bushing

DAS
02
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST039

66

121223

66

**

DAS
6
9-89

DAS
28
9-89

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Work Order ID: 129937

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Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Folding Step LH - Low, High & Float Gear

Start Date: 2/5/2015

Required Date: 2/23/2015

Start Qty: 4.00

Required Qty: 4.00

D3454-5	Manufactured	No	130	Each	21.0000	2	8		DAS 6 9-89
D3454-5								**	

Bushing

DAS
02
9-89
DAS
27
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST040	21	
121224	21	

D3455-1	Manufactured	No	130	Each	17.0000	4	16		DAS 6 9-89
D3455-1								**	

Spacer

DAS
02
9-89
DAS
27
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST040	17	
127825	17	

D3455-3	Manufactured	No	130	Each	17.0000	2	8		DAS 6 9-89
D3455-3								**	

Spacer

DAS
02
9-89
DAS
27
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST040	17	
121684	17	

D3462-041	Manufactured	No	130	Each	1.0000	1	4		DAS 6 9-89
D3462-041								**	

Bracket

DAS
02
9-89
DAS
27
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
st541	1	
121227	1	

Handwritten notes and stamps:

- 8130933 X/K
- 2X
- 3X B 125786
- APR 11 2015
- DAS 6 9-89
- DAS 28 9-89

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Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Folding Step LH - Low, High & Float Gear

Start Date: 2/5/2015

Required Date: 2/23/2015

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

130

Each

1,098.000

3

12

MS21043-3

Nut

DAS

6

9-89

DAS

28

9-89

DAS

02

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

104

m130673

104

GA

397

m130673

15

m131677

382

ST304

517

m131340

517

12
8

MS24665-227

Purchased

No

130

Each

175.0000

2

8

MS24665-227

Cotter Pin

DAS

6

9-89

DAS

28

9-89

DAS

02

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

GA

16

111041

16

ST293

159

m127831

159

8
8

MS24665-229

Purchased

No

130

Each

13.0000

2

8

MS24665-229

Cotter Pin

DAS

6

9-89

DAS

28

9-89

DAS

02

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

GA

13

118234

13

8

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Work Order ID: 129937

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Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Folding Step LH - Low, High & Float Gear

Start Date: 2/5/2015

Required Date: 2/23/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0363R

Purchased

No

130

Each

664.0000

7

28

NAS1149C0363R

Washer

DAS
02 DAS
9-89 27
9-89

Location

Loc Qty

Loc Code

FP001

102

114742

102

GA

180

m130673

180

ST271

382

m130673

382

**

DAS
6
9-89

DAS
28
9-89

28

NAS1149C0563R

Purchased

No

130

Each

791.0000

1

4

NAS1149C0563R

Washer

DAS
02 DAS
9-89 27
9-89

Location

Loc Qty

Loc Code

ST260a

500

m131697

500

ST271

291

m131026

291

**

DAS
6
9-89

DAS
28
9-89

4

NAS1515H5

Purchased

No

130

Each

245.0000

1

4

NAS1515H5

Washer

DAS
02 DAS
9-89 27
9-89

Location

Loc Qty

Loc Code

FG

40

103691

40

ST266

205

125574

5

m130783

200

**

DAS
6
9-89

DAS
28
9-89

APR 21 2015

4

D3463-041

Manufactured

No

110

Each

0.0000

1

4

D3463-041

Step Weldment Assembly

12123

DAS
26
9-89

DAS
26
9-89

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Work Order ID: 129937

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Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Folding Step LH - Low, High & Float Gear

Start Date: 2/5/2015

Required Date: 2/23/2015

Start Qty: 4.00

Required Qty: 4.00

D3443-043

Manufactured No

110

Each

6.0000

1

4

D3443-043

Strut Weldment Assembly

**

DAS
06
9-89

Location

Loc Qty

Loc Code

st541

6

121217

6

4

DAS
26
9-89

D3443-041

Manufactured No

110

Each

6.0000

1

4

D3443-041

Strut Weldment Assembly

**

DAS
06
9-89

Location

Loc Qty

Loc Code

st541

6

125854

2

127760

4

2

DAS
26
9-89

D3443-9

Manufactured No

110

Each

22.0000

2

8

D3443-9

Pin

**

DAS
06
9-89
DAS
26
9-89

Location

Loc Qty

Loc Code

ST039

22

109100

2

125737

20

2

D3454-7

Manufactured No

110

Each

16.0000

2

8

D3454-7

Bushing

**

DAS
06
9-89
APR 07 2015
DAS
26
9-89

Location

Loc Qty

Loc Code

ST040

16

121225

16

8

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Work Order ID: 129937

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Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Folding Step LH - Low, High & Float Gear

Start Date: 2/5/2015

Required Date: 2/23/2015

Start Qty: 4.00

Required Qty: 4.00

D3455-1

Manufactured No

110 Each 17.0000 2 8

D3455-1

Spacer

DAS
03
9-89

Location

Loc Qty

Loc Code

ST040

17

127825

17

8

DAS
26
9-89

D3465-1

Manufactured No

110 Each 21.0000 1 4

D3465-1

Washer

DAS
03
9-89

Location

Loc Qty

Loc Code

ST040

21

121476

21

4

DAS
26
9-89

AN4CH3

Purchased No

110 Each 25.0000 2 8

AN4CH3

Bolt

DAS
03
9-89

Location

Loc Qty

Loc Code

ST346

25

M126085

25

8

DAS
26
9-89

AN4C14

Purchased No

110 Each 23.0000 1 4

AN4C14

Bolt

DAS
06
9-89

Location

Loc Qty

Loc Code

ST344

23

m126461

4

m131264

19

4

DAS
26
9-89

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Work Order ID: 129937

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Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Folding Step LH - Low, High & Float Gear

Start Date: 2/5/2015

Required Date: 2/23/2015

Start Qty: 4.00

Required Qty: 4.00

AN310-4	Purchased	No	110	Each	94.0000	1	4		
AN310-4								**	
Nut									DAS 26 9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	25	
M127815	25	
ST331	69	
M129913	68	
M131320	1	

AN310-7	Purchased	No	110	Each	86.0000	1	4		
AN310-7								**	
Nut									DAS 26 9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST331	86	
24198	46	
m120124	40	

MS24665-227	Purchased	No	110	Each	175.0000	1	4		
MS24665-227								**	
Cotter Pin									DAS 26 9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	16	
111041	16	
ST293	159	
m127831	159	

DAS
26
9-89
APR 07 2015

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Shop Packet Print

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Work Order ID: 129937

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Parent Item: D412-630-031

D412-630-031

Parent Item Name: Pilot/Co-Pilot Folding Step LH - Low, High & Float Gear

Start Date: 2/5/2015

Required Date: 2/23/2015

Start Qty: 4.00

Required Qty: 4.00

MS24665-302

Purchased

No

110

Each

97.0000

1

4

MS24665-302

Cotter Pin

DAS
06
9-89

APR 07 2015

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

36

120521

36

ST293

61

116396

1

MT27305

60

3

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER NAS 1149 CO 363R
1	1	AN960C516	WASHER NAS 1149 CO 563R
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034TM HELI-ACCESS-STEP

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Item ID: D412-630-031 Accept *N19000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pilot/Co-Pilot Folding Step LH - Low, High & Float Gear
 Start Date: 2/5/2015 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 2/23/2015 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLD Date: 1504-07 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-630	Rev N

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy D412-630 bluefile & type labels per PPP412-630-031								

110	Small Fab	0.00							
110									
Small Fab	Memo	0.00							
Small Fab	Assemble as per IIN D412-630								

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control	****ensure tension to retract step is 11 to 18 lbs ****								
	ENSURE STEP IS A LH: _____								

MLD 1504-21

(4)

4X

15/04/20

DAS
36
9-89

(4)

DAS
30
9-89

APR 20 2015